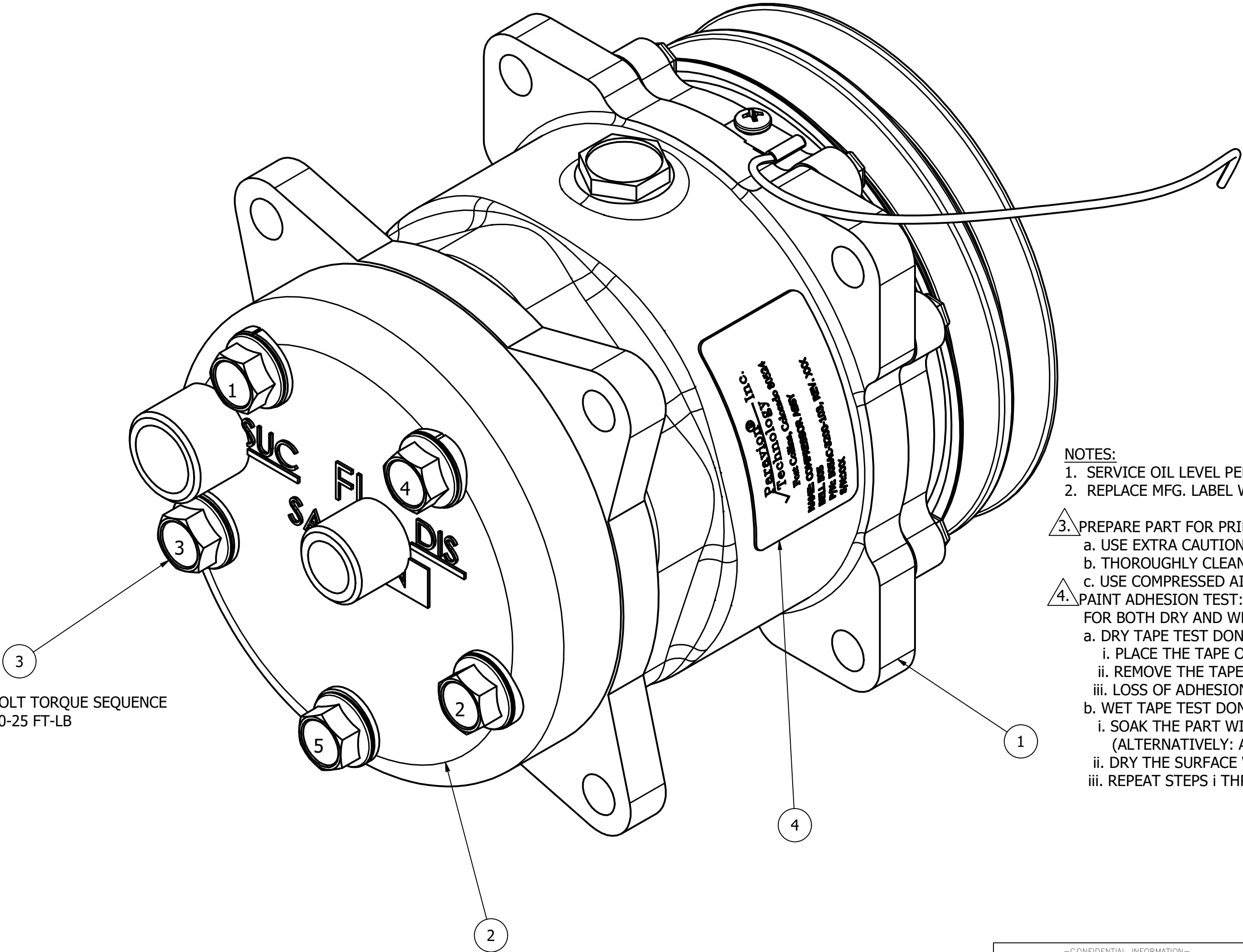


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ES10505-2	COMPRESSOR WITHOUT CYLINDER HEAD
2	1	ES12505-1	CYLINDER HEAD KIT WITH GASKET
3	1	ES12505-2	HEAD BOLT KIT
4	1	505AC-6120-2	LABEL

REVISION HISTORY						
DATE	REV	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED	
03/13/17	A	ADDED NOTES 3 AND 4; CHANGED THE FINISH AND PAINT ON -25 AND -26; FOR -24, ADDED 0.210/0.220 DIA. HOLES 4X.	JT	LS	JT	
3/31/17	B	ADDED BEND RADIUS CALLOUT AND DIM .206/.196 WAS .218 ON -24, NOTE 4 PAINT TEST WAS PER MONTH, MATERIAL SPEC WAS MILS-**** ON -22 AND -24, ADDED BEND TABLE TO -3, -22, -24.	EW	LS	JT	
7/19/17	C	FILLED IN CHECKED BY AND APPROVED INITIALS REVS PR2 TO B, REV B AUTHOR WAS ETW.	EW	LS	JT	
9/20/17	D	-24 COMPRESSOR Z CHANNEL FWD SHT. 7 REMOVED 4X .196-.206DIA MOUNT HOLES	EW	LS	JT	
4/5/18	E	SHT 4 -3 BRACE 0.863" WIDE TAB WAS 0.615" LONG; REV D HOLES PUT BACK IN AS THEY WERE MISTAKENLY REMOVED THE PREVIOUS REVISION.	EW	LS	EW	
7/23/18	F	SHT 7, REV E INNACCURATE, 4X HOLES ADDED BACK TO -24, NOW SAME AS -24 REV C	ZA	LS	EW	
11/08/18	G	SHT 4: MADE 1" FOLDED DIMENSION REFERENCE; SHT 6: ADDED 0.3" CUT (C3) TO AVOID DRAINHOLE ON -22 Z CHANNEL, REVERSED BEND ORDER; SHT 9: HOLE WAS Ø.203 NOW Ø.210, ADDED 3X TO DIM.	ZA	LS	ZA	
10/21/19	H	ADDED -31, -41 THRU -47 PARTS TO REPLACE 206AC PARTS	ZA	LS	ZA	
1/7/21	J	-42: ENTERED LINE BETWEEN FINISHES, CHANGED "OPTIONAL FINISH" TO "ALTERNATE FINISH", REMOVED "PAINT:" FROM LAST LINE; -43 & -44: MADE ALTERNATE FINISH IDENTIAL TO -42	ZA	DT	MH	
10/22/21	K	-41: CHANGED FLANGE DIM FROM 0.620 TO 0.631, DESCRIPTION WAS 'SPACER PLATE' NOW 'PULLEY'	ZA	DT	ZA	

-103 COMPRESSOR ASSY



- NOTES:
- SERVICE OIL LEVEL PER MFG. INSTRUCTIONS
 - REPLACE MFG. LABEL WITH 4
 - PREPARE PART FOR PRIMER:
 - USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
 - THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
 - USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.
 - PAINT ADHESION TEST:

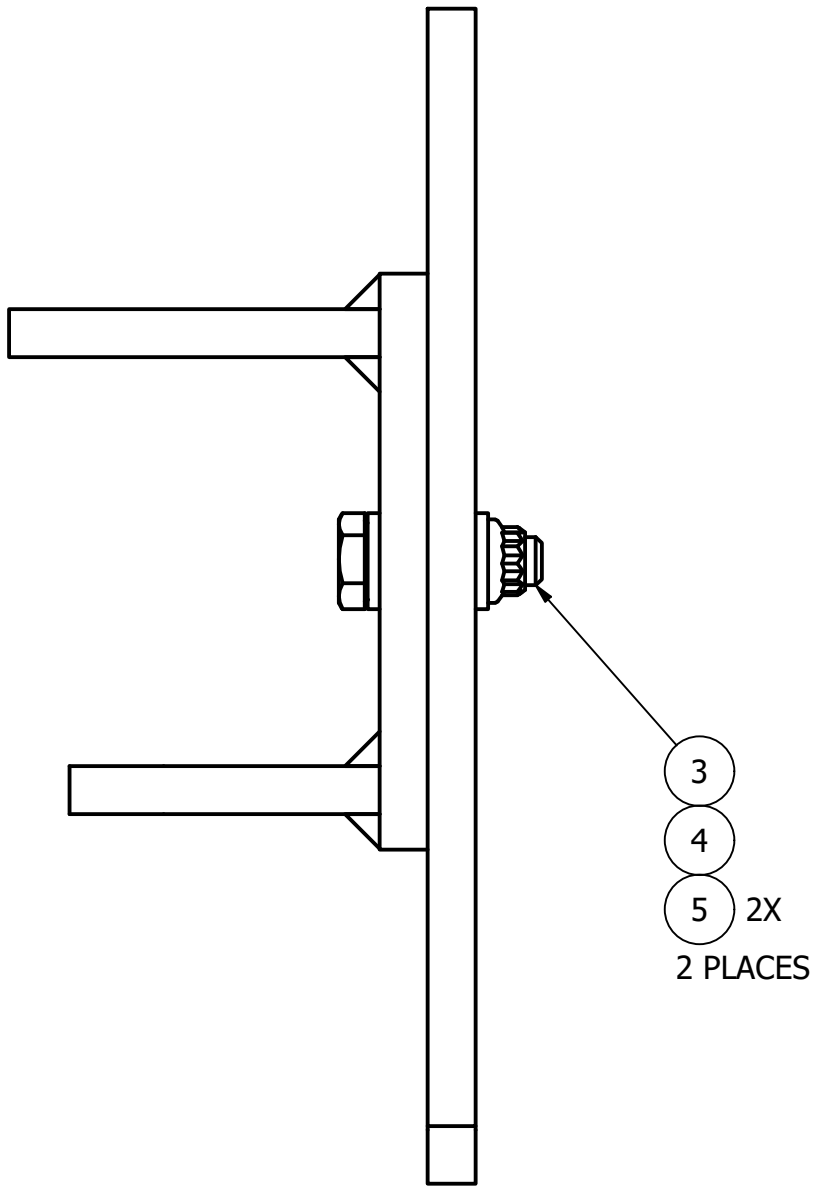
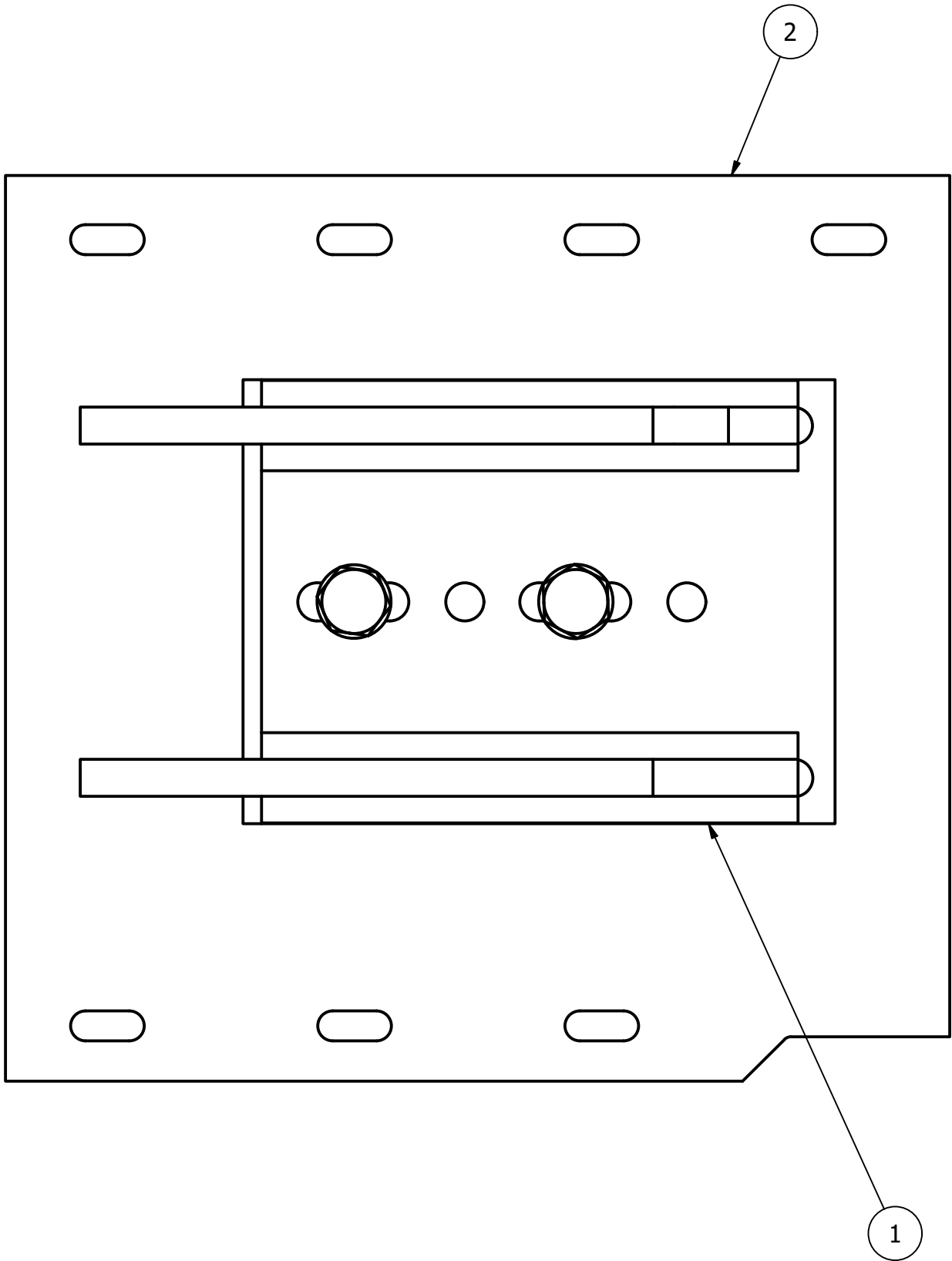
FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.

 - DRY TAPE TEST DONE ONCE EVERY LOT.
 - PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
 - REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
 - LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.
 - WET TAPE TEST DONE ONCE PER LOT.
 - SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS. (ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
 - DRY THE SURFACE WITH A CLEAN CLOTH.
 - REPEAT STEPS i THRU iii OF DRY TAPE TEST.

Paravion [®] Inc.		TITLE		DRAWING NUMBER	
Technology		COMPRESSOR AND COMPONENTS		505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY	CHK'D BY	APRVD. BY	DATE
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		KEW	LS	JT	3/3/16
3RD ANGLE PROJECTION		DO NOT SCALE DRAWING		SHEET	
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	206AC-3025-1	TOP PLATE ASSEMBLY
2	1	505AC-3200-25	BASE PLATE
3	2	AN4-7A	BOLT
4	4	NAS1149F0463P	WASHER
5	2	NAS9926-4L	LOCKING NUT

-20 PLATE ASSY



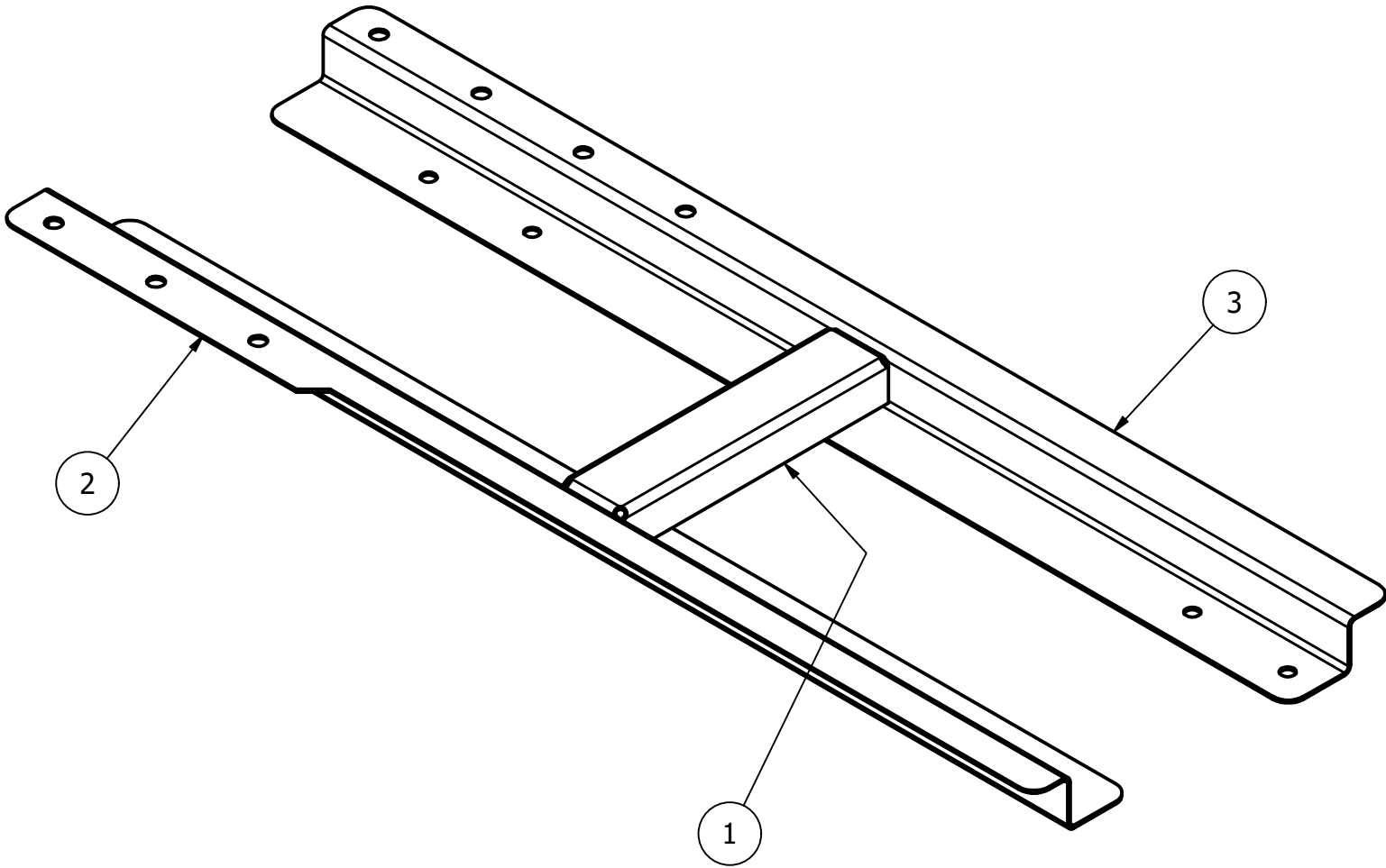
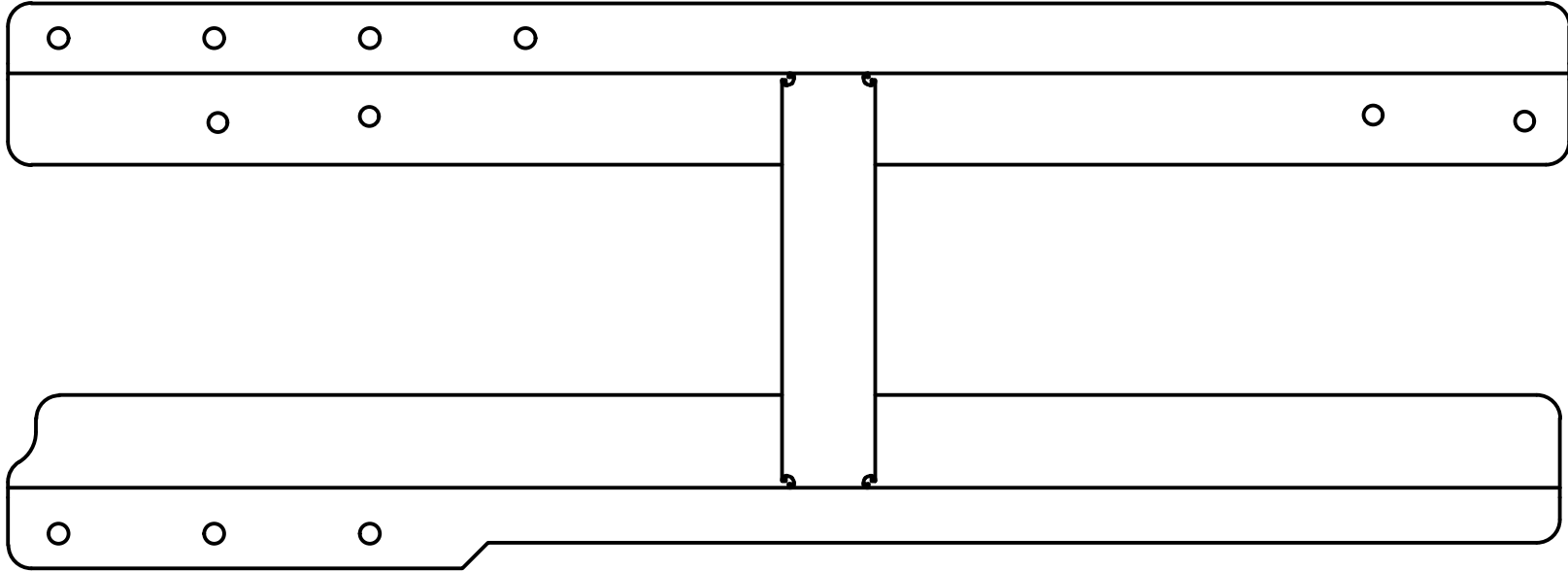
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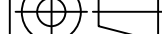
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THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING				SHEET 2 OF 13	
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-3200-3	BRACE
2	1	505AC-3200-22	COMPRESSOR Z CHANNEL AFT
3	1	505AC-3200-24	COMPRESSOR Z CHANNEL FWD
5	4	CR3523-4-02	RIVET

-21 Z CHANNEL ASSY



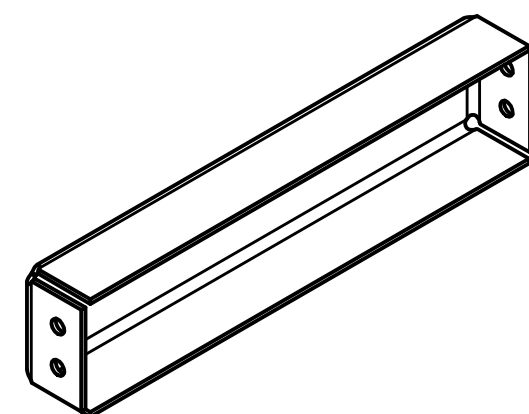
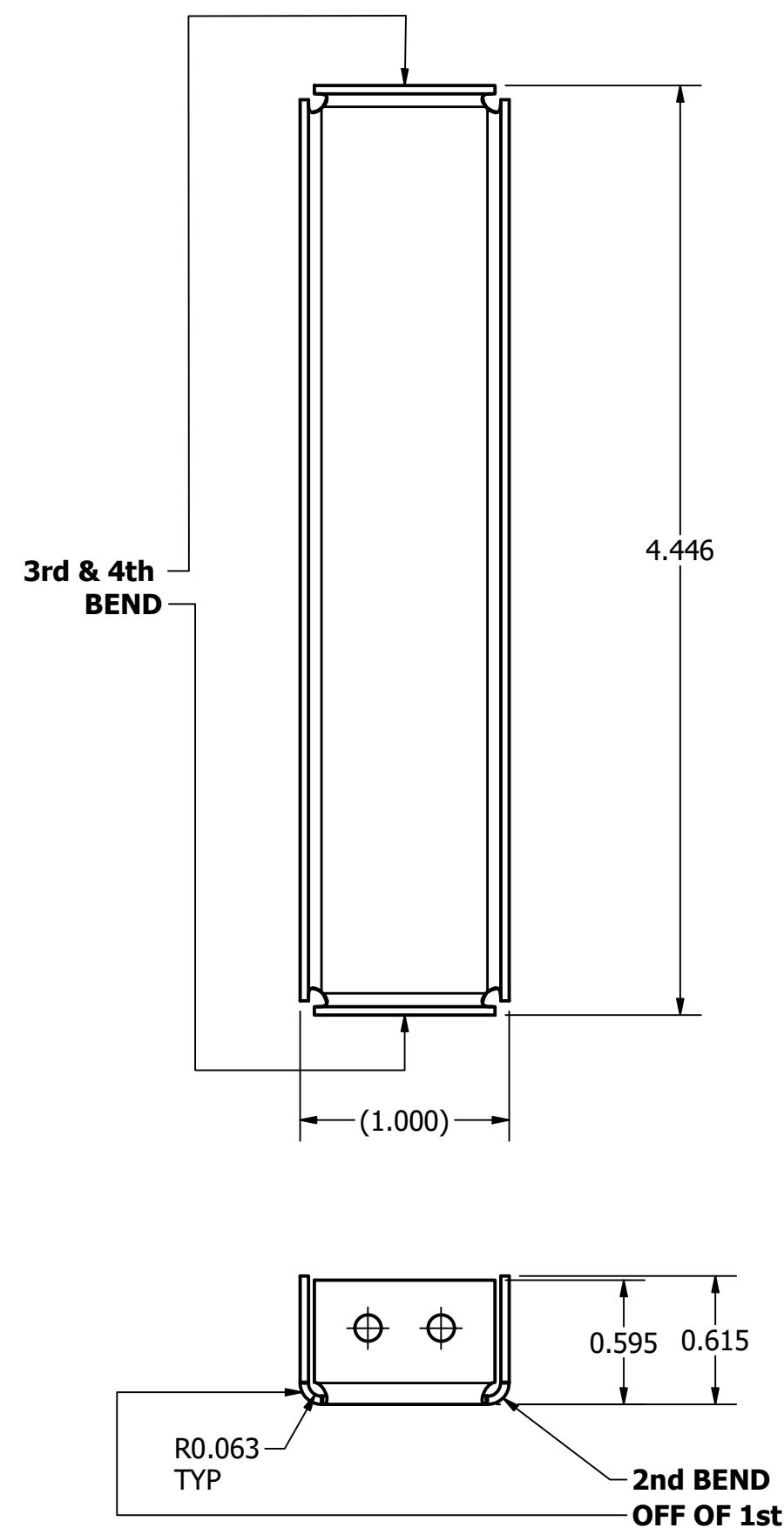
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	DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO
	KEW	LS	JT	3/3/16	K	
					SHEET	
	DO NOT SCALE DRAWING				3 OF 13	
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PROTO

FINISH: NONE


BEND CHART			
	1st BEND	2nd BEND	3rd & 4th BEND
PUNCH	#6	#6	#6
DIE	#1	#1	#1
ANGLE	85°	85°	87°
DIMENSION	.559	.956	.559



BREAK ALL SHARP EDGES

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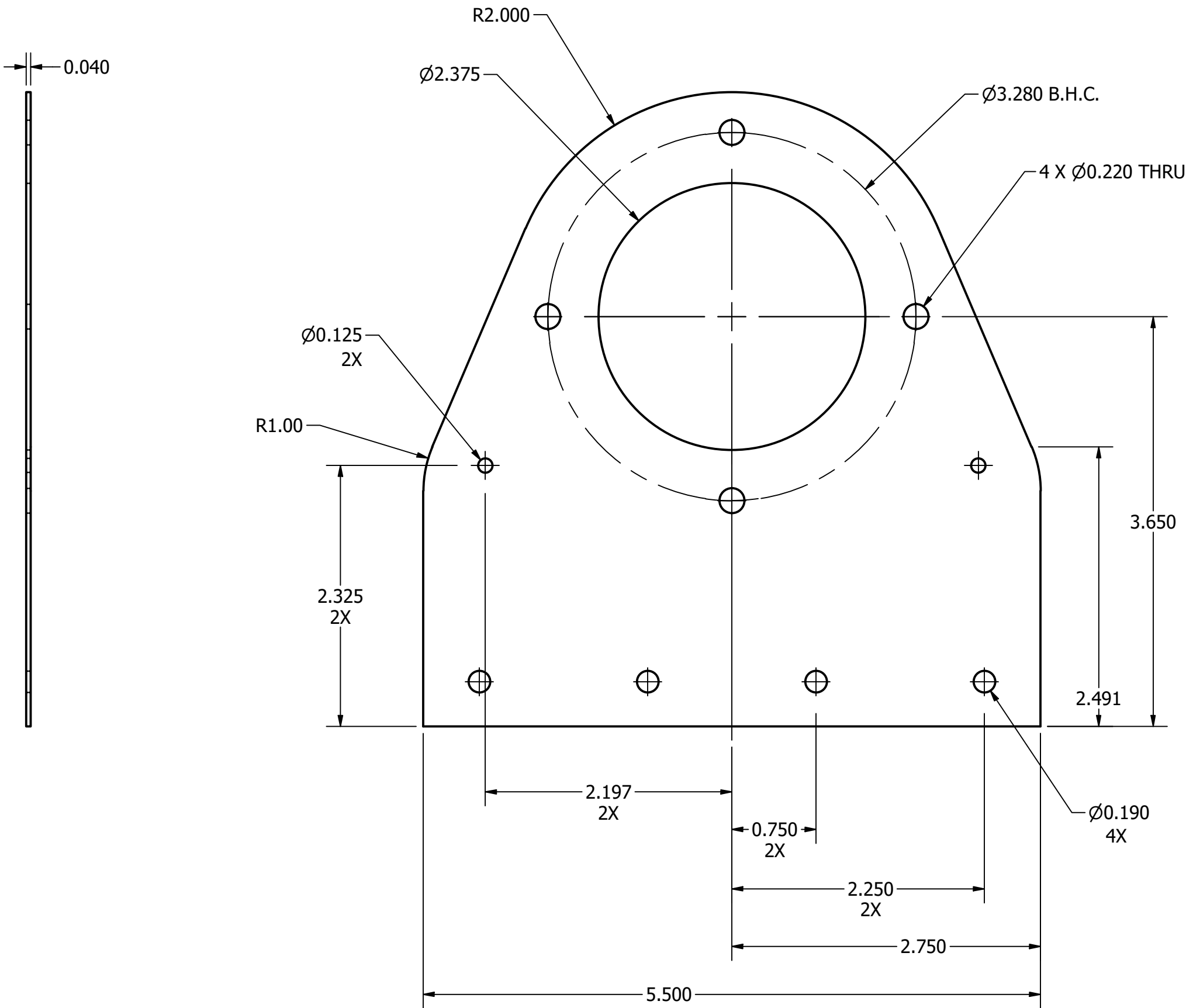
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Paravion® Technology Inc.	TITLE				DRAWING NUMBER	
	COMPRESSOR AND COMPONENTS				505AC-3200	
	DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:				REV	ECO
	DRAWN BY	CHK'D BY	APRVD. BY	DATE		
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°	KEW	LS	JT	3/3/16	K	
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A	 DO NOT SCALE DRAWING © 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.				SHEET 4 OF 13	

-9 DOUBLER

MATERIAL: 301,304,316 1/4 HARD 0.040" THK, MILS-5059-D-Amend. 3, AMS5517, ASTM-A666-94.


FINISH: NONE



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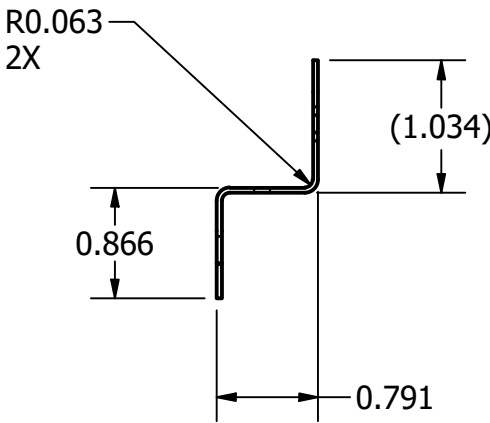
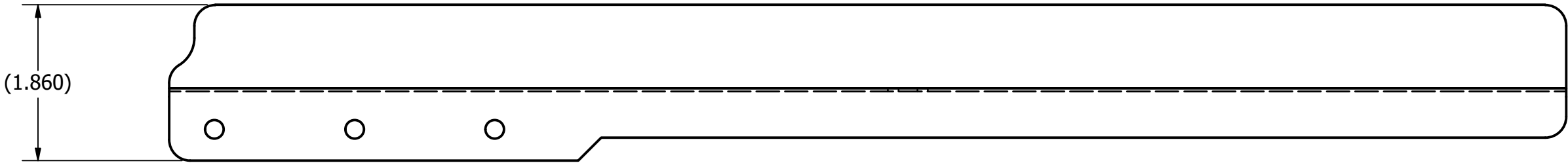
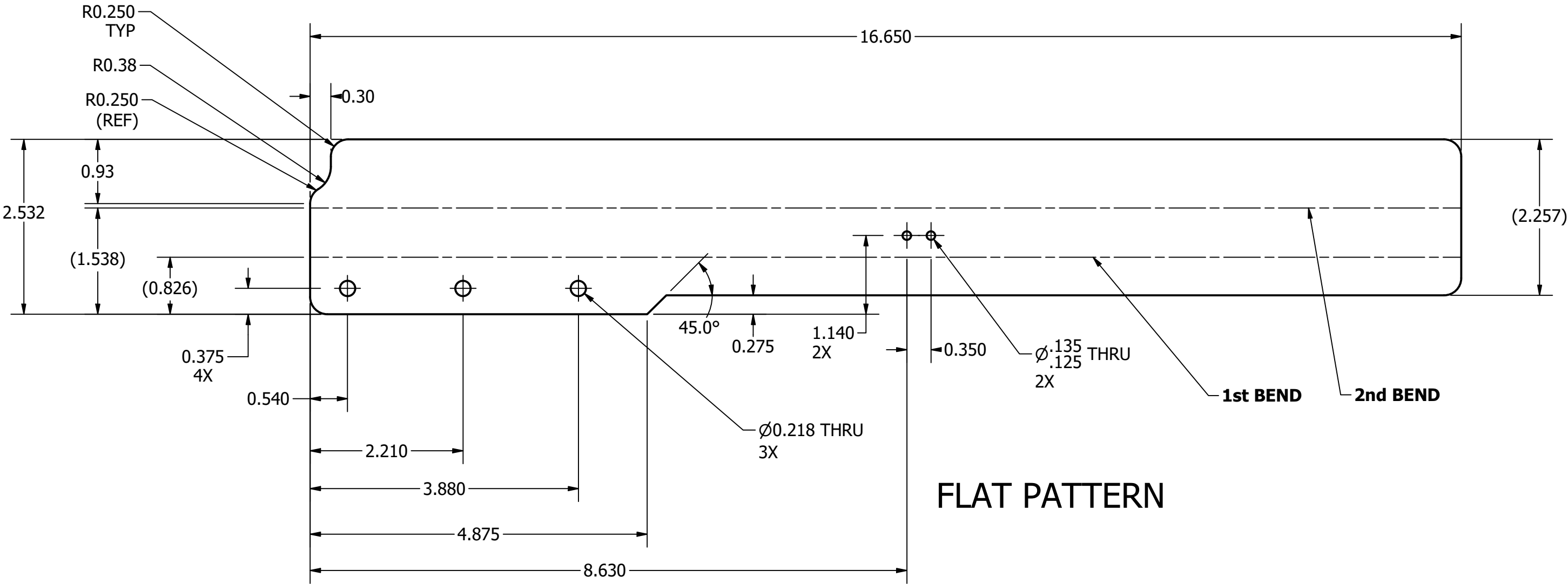
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<div>Paravion[®] Technology Inc.</div>		TITLE				DRAWING NUMBER	
		COMPRESSOR AND COMPONENTS				505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1° THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO
		KEW	LS	JT	3/3/16	K	
							
		DO NOT SCALE DRAWING				SHEET	
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-22 COMPRESSOR Z CHANNEL AFT

MATERIAL: 301,304,316 1/4 HARD 0.040" THK, MIL-S-5059-D-Amend. 3, AMS5517, ASTM-A666-94.
FINISH: NONE

BEND CHART		
	1st BEND	2nd BEND
PUNCH	#6	#6
DIE	#20	#20
ANGLE	87.5°	87.5°
DIMENSION	.761	.835



BREAK ALL SHARP EDGES

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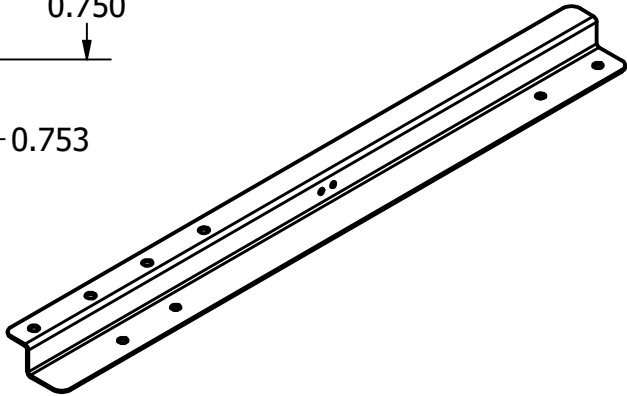
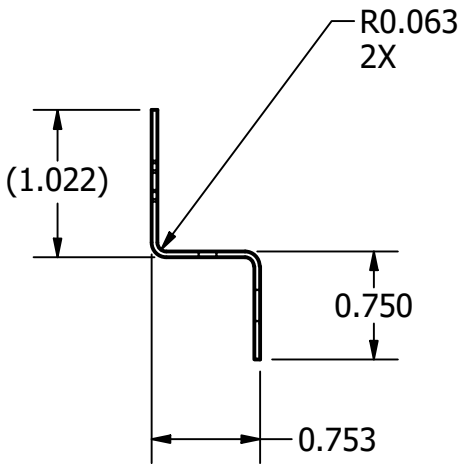
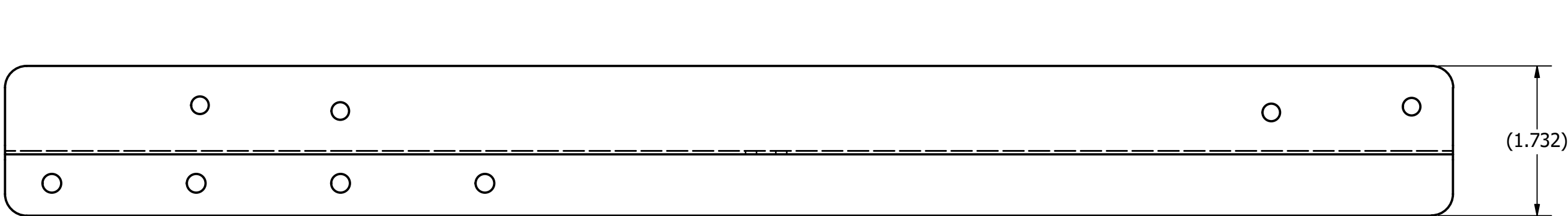
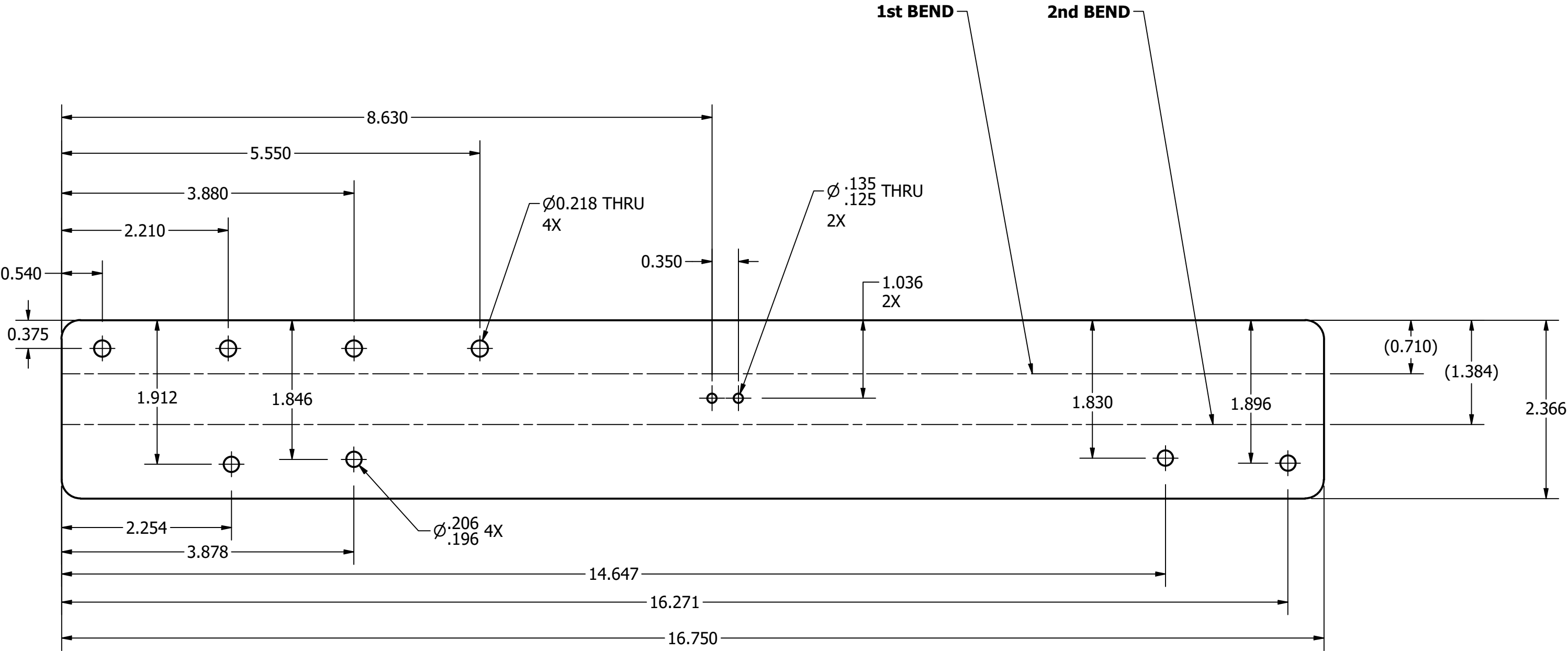
Paravion [®] Technology Inc.		TITLE COMPRESSOR AND COMPONENTS				DRAWING NUMBER 505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16	REV K	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING				SHEET 6 OF 13	
3RD ANGLE PROJECTION		© 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					

-24 COMPRESSOR Z CHANNEL FWD

MATERIAL: 301,304,316 1/4 HARD 0.040" THK, MIL-S-5059-D-Amend. 3, AMS5517, ASTM-A666-94.

FINISH: NONE

BEND CHART		
	1st BEND	2nd BEND
PUNCH	#6	#6
DIE	#20	#1
ANGLE	88°	81°
DIMENSION	.702	.700



BREAK ALL SHARP EDGES

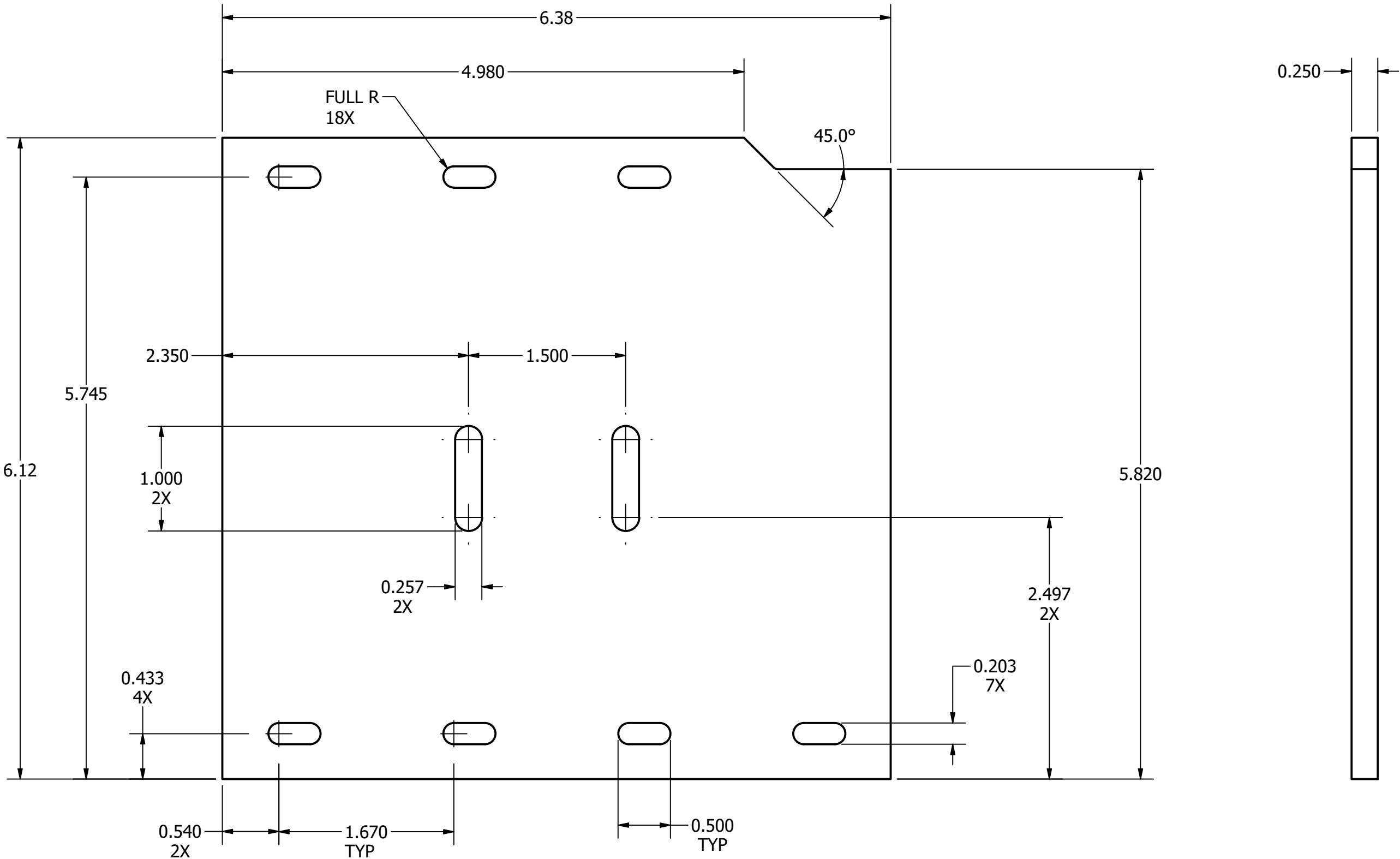
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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		REV K	ECO
3RD ANGLE PROJECTION		© 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		SHEET 7 OF 13	

-25 BASE PLATE 3

MATERIAL: 6061-T6 0.250" THK QQ-A-250/11, AMS 4025, AMS 4026, AMS 4027
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.
PAINT ADHESION TEST: 4



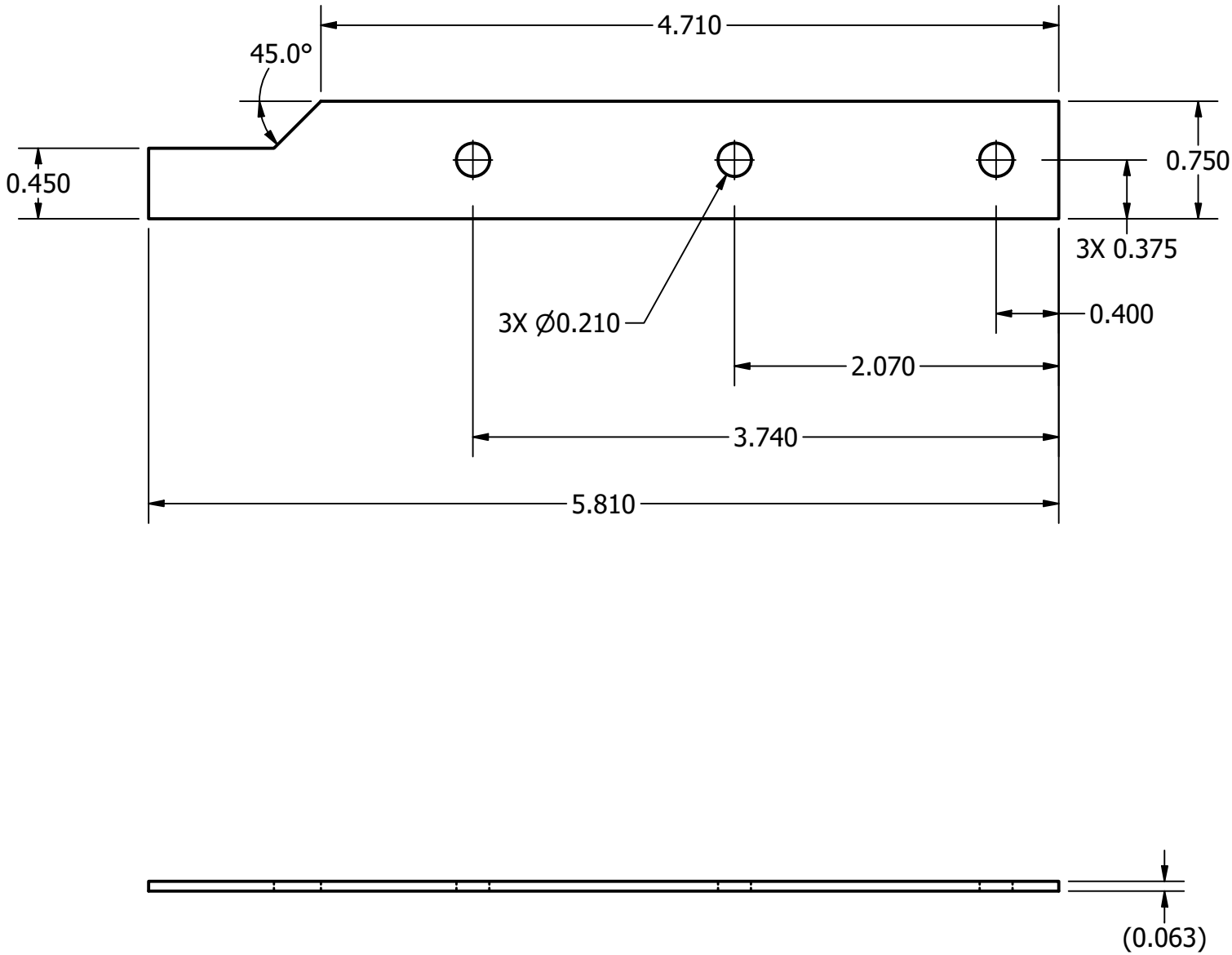
Paravion [®] Technology Inc.		TITLE COMPRESSOR AND COMPONENTS		DRAWING NUMBER 505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		REV K	ECO
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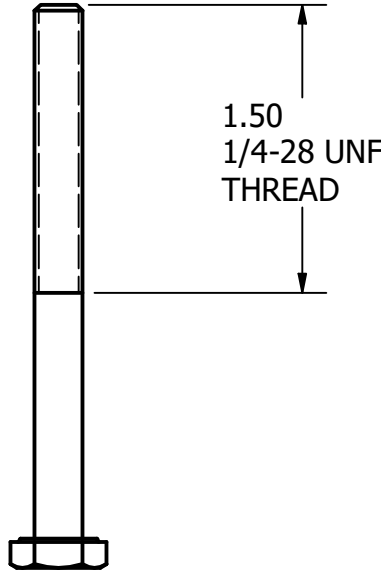
-26 SPACER PLATE 3

MATERIAL: 6061-T6 0.063" THK QQ-A-250/11, AMS 4025, AMS 4026, AMS 4027
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.
PAINT ADHESION TEST:4




-27 BOLT

MATERIAL: MADE FROM AN4-26A



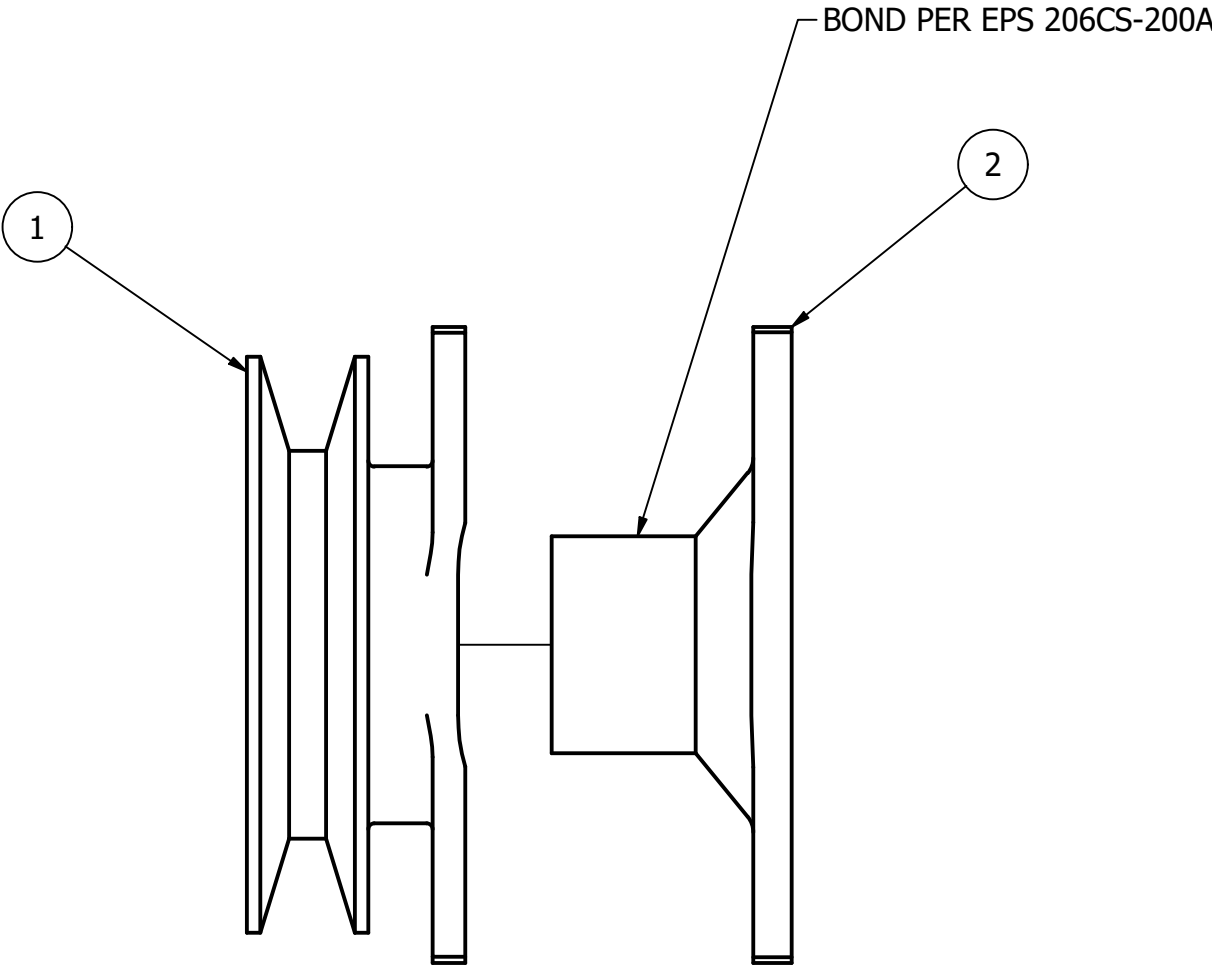
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PROTO

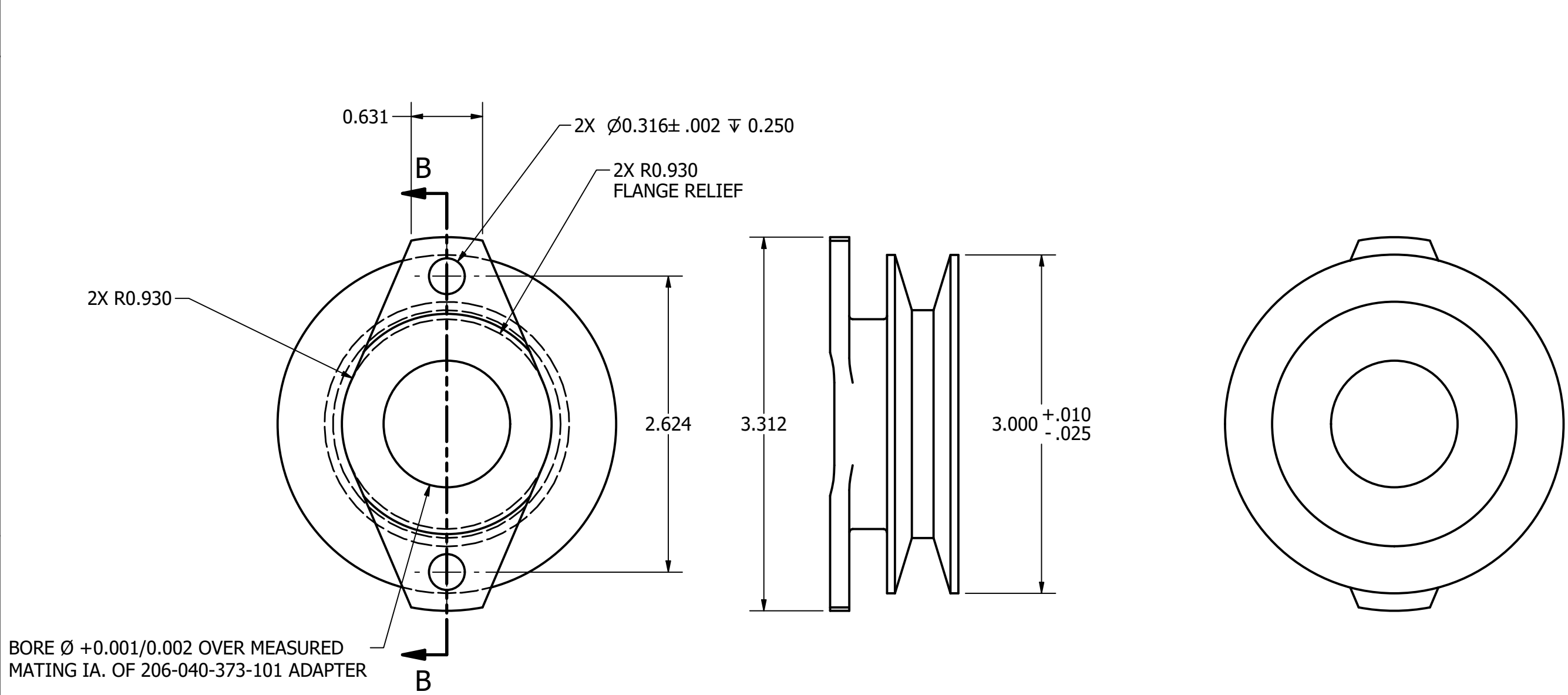
<div>Paravion[®] Technology Inc.</div>		TITLE COMPRESSOR AND COMPONENTS				DRAWING NUMBER 505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1° THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16	REV K	ECO
						SHEET 9 OF 13	
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-3200-41	PULLEY
2	1	206-040-373-101	ADAPTER

-31 PULLEY ASSEMBLY



BREAK ALL SHARP EDGES

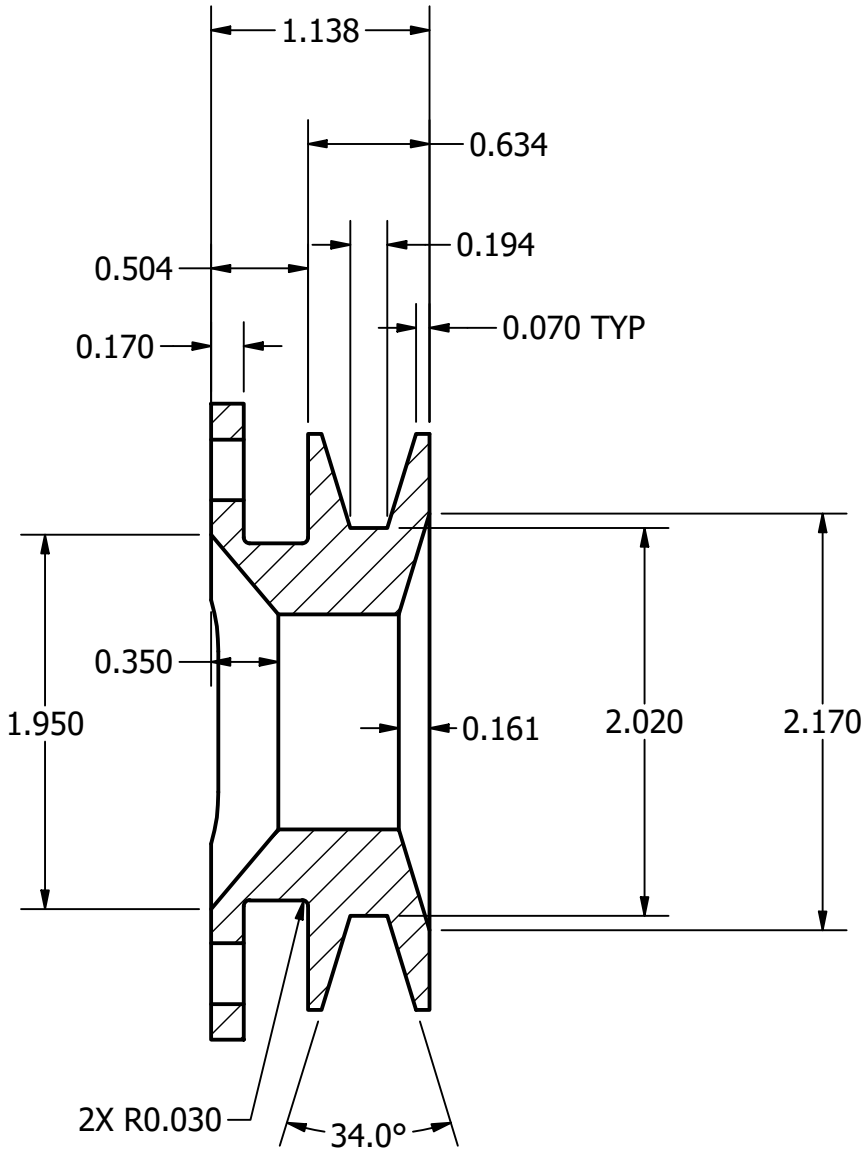


BORE Ø +0.001/0.002 OVER MEASURED
MATING IA. OF 206-040-373-101 ADAPTER

-41 PULLEY

MATERIAL: 416 SS, PER AMS 5610 TYPE II, ASTM: A314, A484, A582
WEIGHT: 0.88 LBS
SURFACE FINISH 125✓

BREAK ALL SHARP EDGES



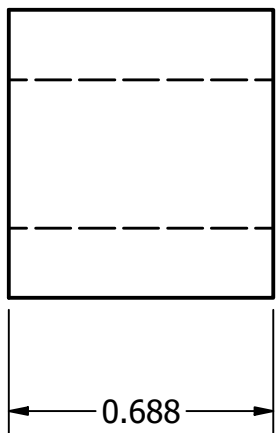
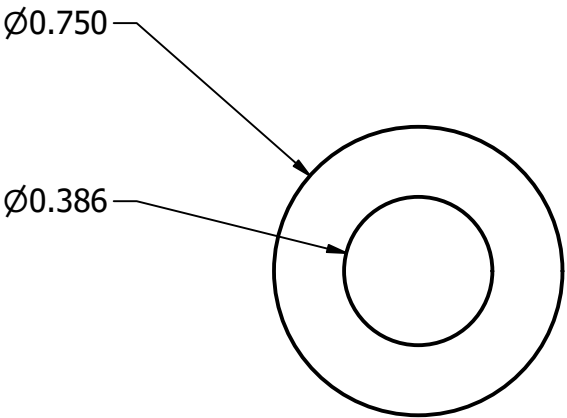
SECTION B-B

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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°	DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16	REV K
	DO NOT SCALE DRAWING				ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		3RD ANGLE PROJECTION		SHEET 10 OF 13	

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PROTO

D



-42 SPACER

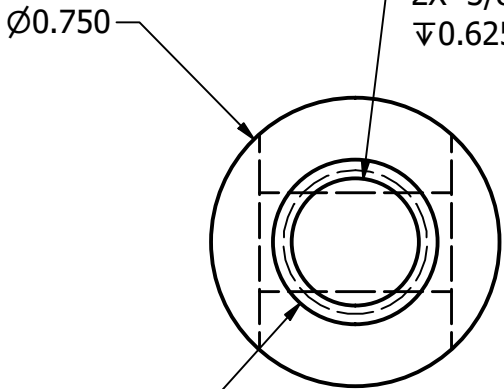
MATERIAL: 6061-T6 ALUMINUM PER Q-A-225/8 OR QQ-A-200/8
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2.

COLOR: BLACK
WEIGHT: 0.05

ALTERNATE FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 1,
EXCEPT OMIT SEALING IN SECTION 3.8.1.2
PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

BREAK ALL SHARP EDGES

3



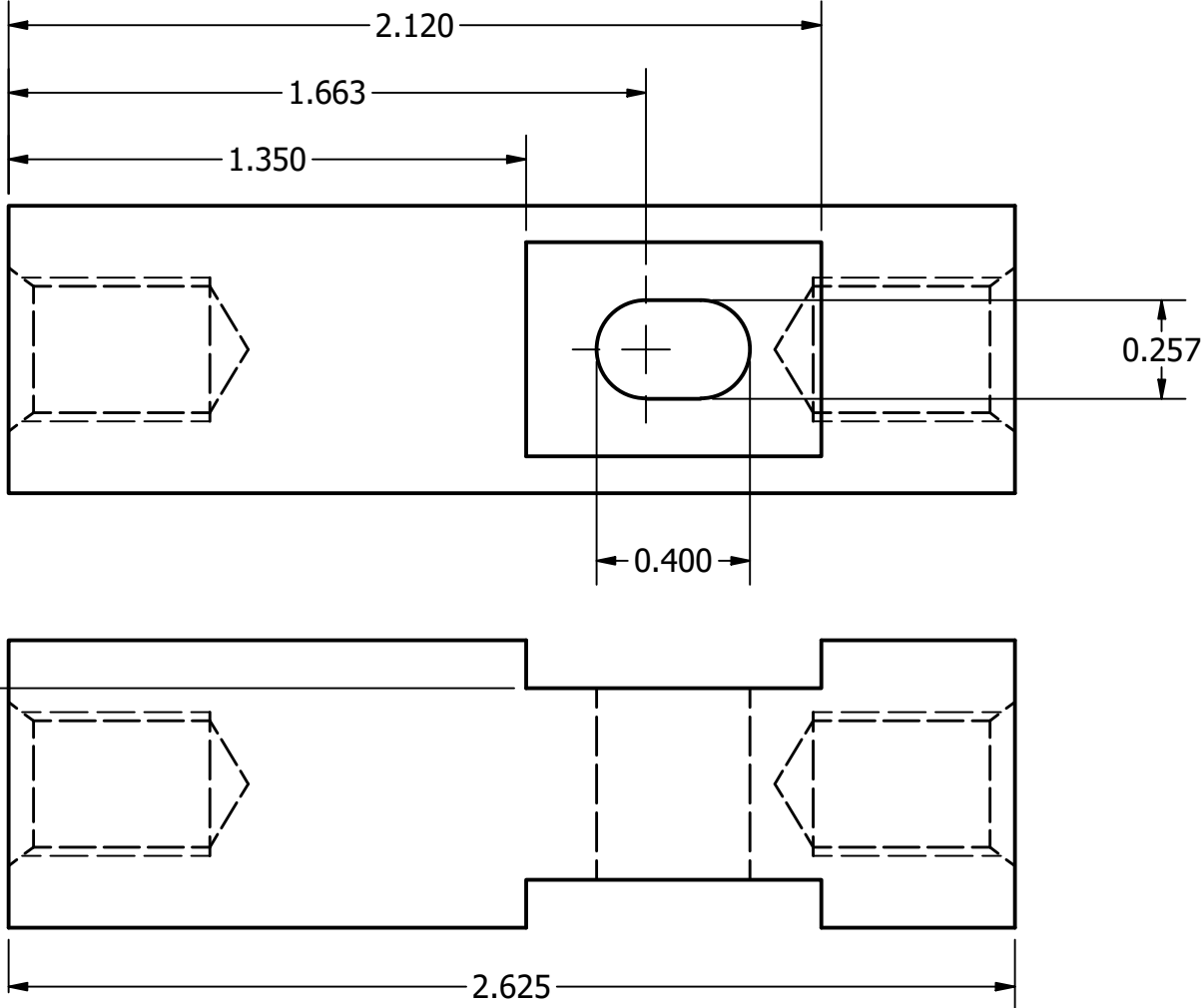
2X 37° CHAMFER
X 0.035 DEEP

-43 RESTRAINT

MATERIAL: ALUMINUM 6061-T6 QQ-A-200/8
FINISH: ANODIZE PER MIL-A-8625, TYPE II, CLASS 2
COLOR: BLACK
SURFACE FINISH \checkmark^{125}

ALTERNATE FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 1,
EXCEPT OMIT SEALING IN SECTION 3.8.1.2
PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

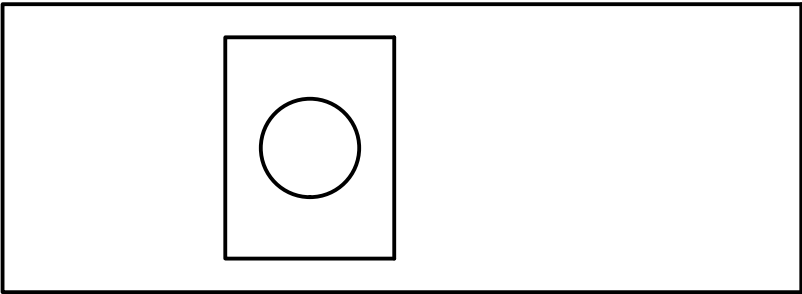
2



-44 RESTRAINT

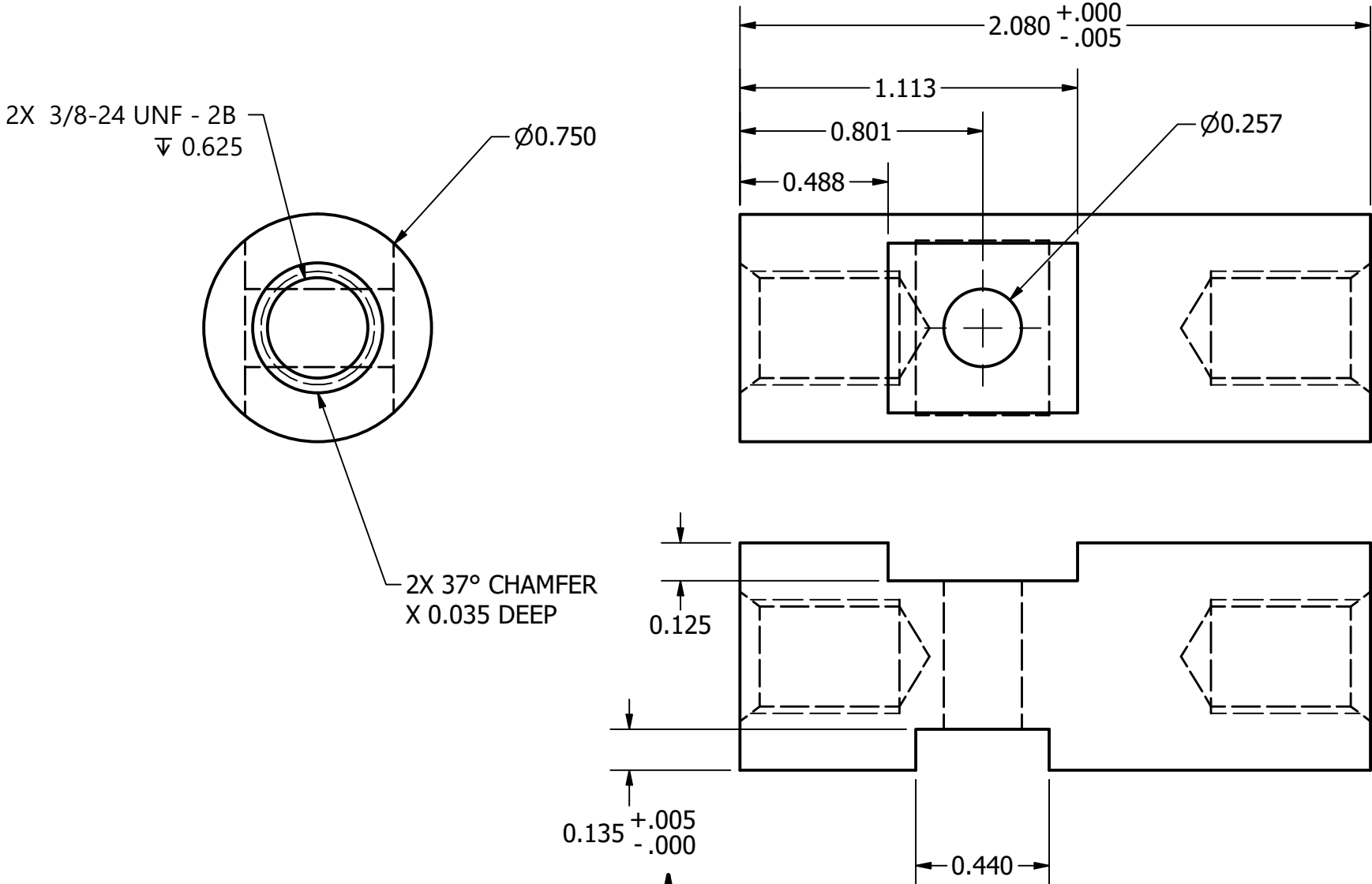
MATERIAL: ALUMINUM 6061-T6 QQ-A-200/8
FINISH: ANODIZE PER MIL-A-8625, TYPE II, CLASS 2
COLOR: BLACK
SURFACE FINISH \checkmark^{125}

ALTERNATE FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 1,
EXCEPT OMIT SEALING IN SECTION 3.8.1.2
PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.



VIEW C-C

B



A

BREAK ALL SHARP EDGES

4

3

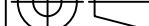
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1

1

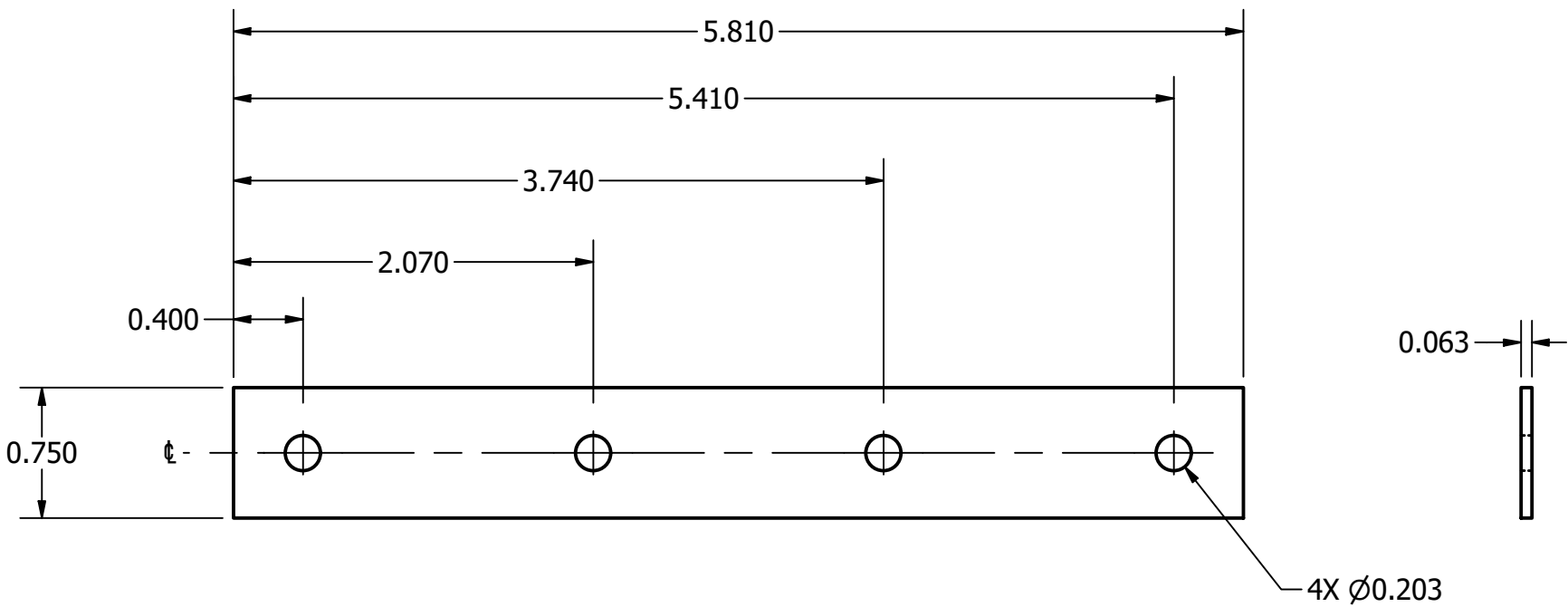
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<div>Paravion® Technology Inc.</div>		TITLE				DRAWING NUMBER	
		COMPRESSOR AND COMPONENTS				505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES=± 1° THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO
		KEW	LS	JT	3/3/16	K	
		DO NOT SCALE DRAWING				SHEET	
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		3RD ANGLE PROJECTION					

-45 SPACER PLATE

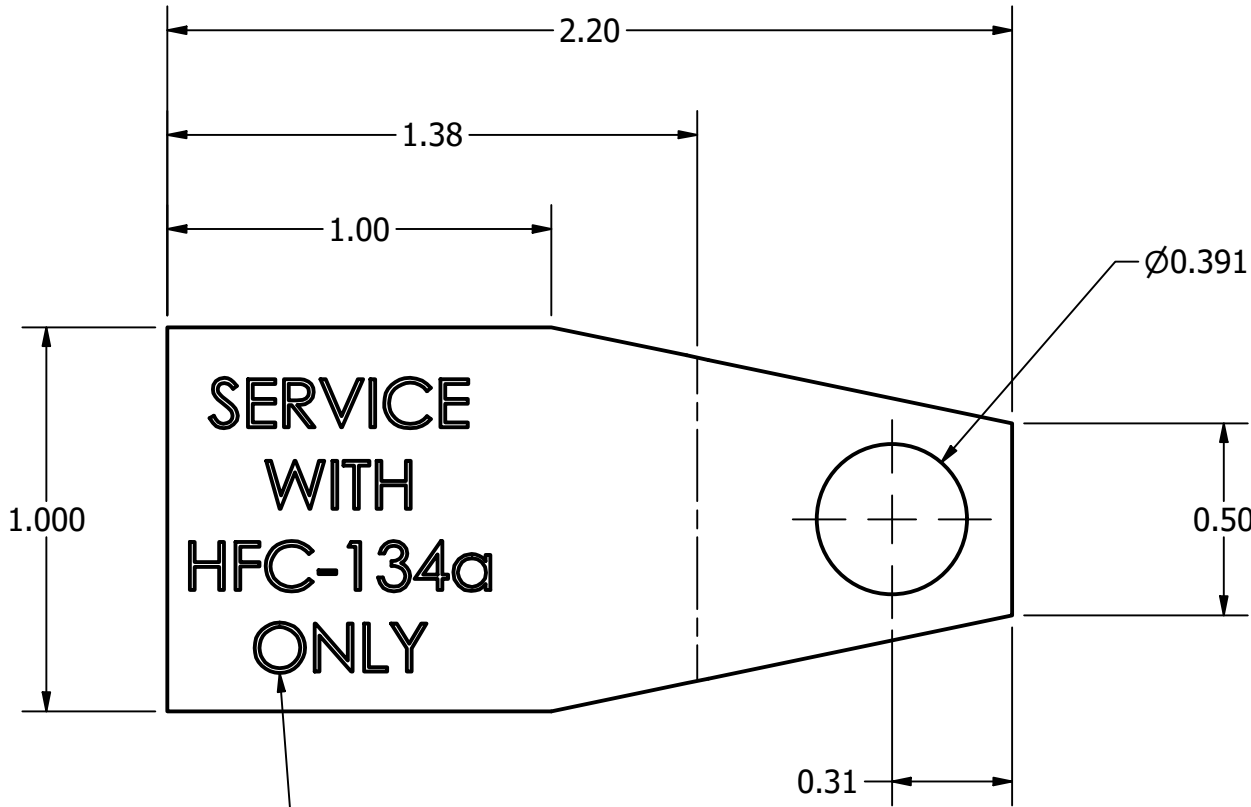
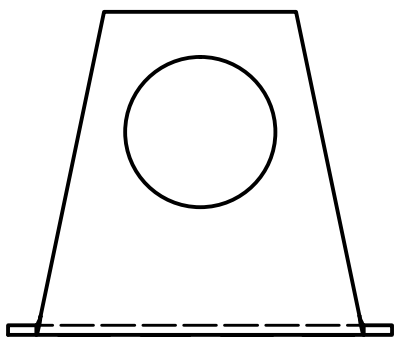
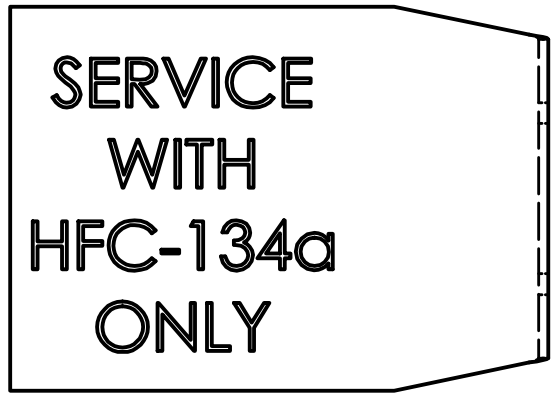
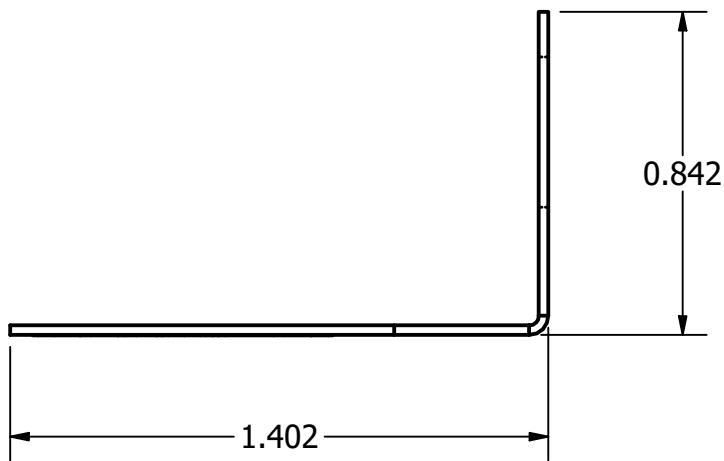
MATERIAL: ALUMINUM 6061-T6 QQ-A-250/11
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.



BREAK ALL SHARP EDGES

-46 PLACARD

MATERIAL: 0.025 SHEET, 6061-T6 ALUMINUM PER QQ-A-250/11
ALT. MATERIAL: 5004-H34 ALUMINUM
FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2



FLAT PATTERN LETTERING TO BE 0.125 IN. TALL ENGRAVED PRIOR TO BENDING

BREAK ALL SHARP EDGES

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PROTO

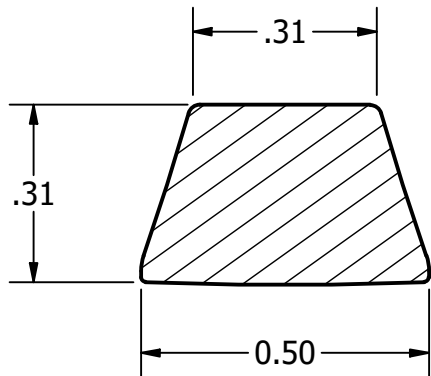
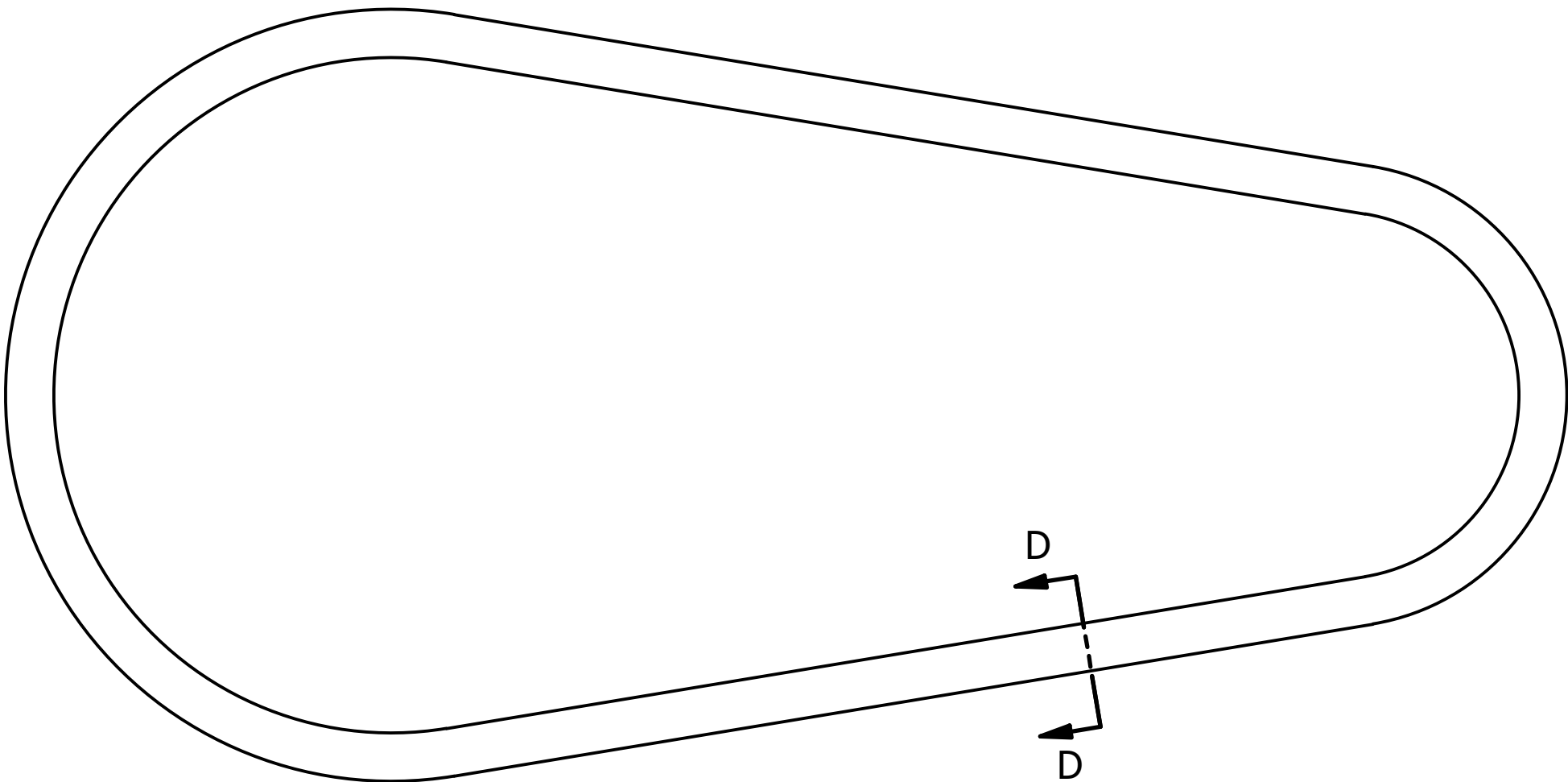
Paravion [®] Technology Inc.		TITLE COMPRESSOR AND COMPONENTS				DRAWING NUMBER 505AC-3200	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/3/16	REV K	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING				SHEET 12 OF 13	
3RD ANGLE PROJECTION		© 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					

- NOTES:
1. THIS DRAWING DEFINES THE OVERALL GEOMETRY AND PERFORMANCE SPECIFICATIONS OF THE PART/ASSEMBLY, AND CONSTITUTES THE ACCEPTANCE CRITERIA THEREOF. CONFORMANCE OF HARDWARE TO THESE ACCEPTANCE CRITERIA THEREOF. CONFORMANCE OF HARDWARE TO THESE REQUIREMENTS IS ACCEPTABLE IN LIEU OF VENDOR DOCUMENTATION.

2. ACCEPTED MFR'R:
- A. GATES RUBBER COMPANY
990 SOUTH BROADWAY
DENVER, COLORADO 80217
PHONE: (303)-744-1911
FAX: (303)-744-4000
- B. HBD/THERMOID
2400 SOUTH U.S. HIGHWAY 1
ELGIN, SOUTH CAROLINA
PHONE: (800)-433-8208

-47 BELT

MANUFACTURER	MFR'R P/N	CORD CONSTR.	OUTSIDE CIRCUMFERENCE (IN)
GATES RUBBER COMPANY	6825	ARAMID FIBER	24.8
HBD/THERMOID	A23	ARAMID UNICORD	24.7 (RMA DATUM LENGTH 24.3)



SECTION D-D

BREAK ALL SHARP EDGES

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<div>DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1° THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A</div>		DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO
		KEW	LS	JT	3/3/16	K	
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